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Page 1

**Accept**

[illegible]

**Setup Start**

(b) (5) DPP, (b) (7)(C), (b) (7)(D)

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[illegible]

**Start Date:** 03/05/2010    **Start Qty:** 6.00

**Cust Item ID:**

**Required Date:** 13/05/2010      **Req'd Qty:** 6.00

[illegible]

**Customer:**

Run Start

[illegible]

**Approvals:**                      **Process Plan:**

Date: 16-5-03

### Tooling:

Date:

**Stop**

[illegible]

**QC:**

Date:

**SPC (Y/N):**

Date:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58281**

May 3, 2010 9:55:03 AM



Page 2

Item ID: D3136-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 03/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Thermoform Thermoforming Machine	THERMOFORMING MACHINE  Memo 1-Thermoform as per Dwg D3136 and Folio FTA002□Dwg Rev. _____□Folio Rev. _____□2- Engrave Part # and Batch # , and affix labels □ (D3136-3) 34554 X12	0.00  0.00							BB 10/05/17 X6
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00							BB 10/05/17 X6
150  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							8 10/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Page 3

**Accept**

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**Setup Start**

**Stop**

**Abstract**

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

\_\_\_\_\_

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

[REDACTED]

## HAND FINISHING THERMOFORMING

Thermoform

## Memo

0.00

### Thermoforming Machine

Water sand and buff to remove scratches as required

BB  
10/05/07  
X6

0.00

[illegible]

QC5- Inspect part completeness to step on W/O

QC

## Memo

0.00

## Quality Control

8 w/05/18

(16)

0.00

[illegible]

Identify as per dwg & Stock Location: JK

### Packaging

## Memo

0.00

### Packaging

10-5-20 BSF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58281**

May 3, 2010 9:55:03 AM

Page 4

Item ID: D3136-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Window Assembly

Start Date: 03/05/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
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QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ll 10/05/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

May 3, 2010 9:55:08 AM

Page 1

Work Order ID: 58281

Parent Item: D3136-043

Parent Item Name: Window Assembly


Comments: IPP Rev:A 04.02.04 New issue KJ/DS  
IPP Rev.B 07.05.29 Thermoform in-house DL  
IPP rev C 07.09.28 Rev E dwg EC verified by:DD

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D3108-9		Manufactured	No			100	Each	732.0000	2			
												
Decal												

Location	Loc Qty	Loc Code
ST036	732	
34554	232	
46546	500	

MACRLICS.125 Purchased No 170 sf 14.4000 3.9



1/8" Polycast II Sheet

Location	Loc Qty	Loc Code
MAT	14.4	
113204	4	
113861	10.4	

114673

12 30/05/17

B10-5-13

32,

114673

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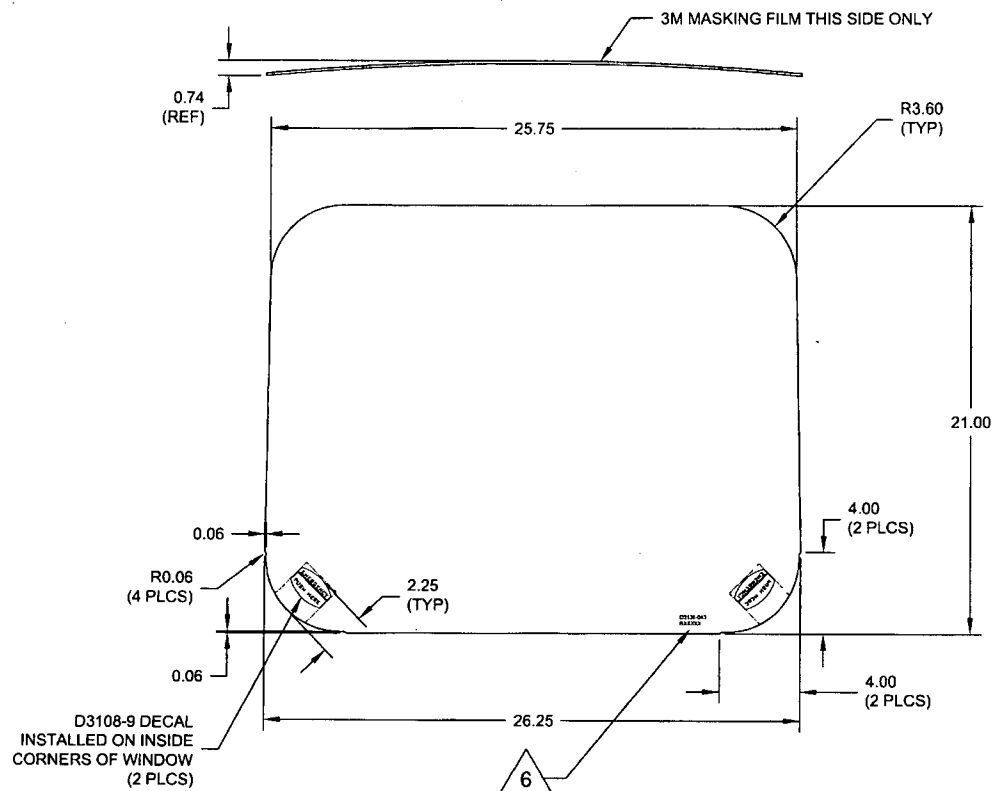
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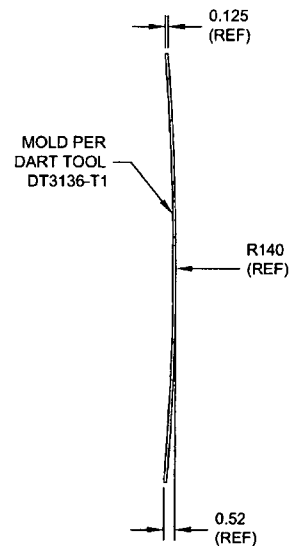
**NOTE:** Date & initial all entries



**D3136-3 WINDOW**  
**D3136-043 WINDOW ASSEMBLY**  
 (INCLUDES D3108-9 DECALS)

**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS



W/O 58281

**RELEASED**  
 07.09.22

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:6
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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